



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D2580-1**Job Sheet 207804****Part No:** D2580-1**Job Qty:** 8 pcs**Part Name:** 205 Bent Tube**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 3/4/20**Job Tracking No:****Due Date:** 3/20/20**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: DWG D2580 REV h SHEETS 1,2,3,8 IPP B 01.11.08 Revised Step 9, 10, 12, and 13 SM IPP Rev:C 10.12.01
as per DEO D1 DD verf:ec

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	8 pcs	3/20/20		0.00	7.41	Skidtubes - 1		02
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
101	QC 5	8	3/20/20		0.00	0.00	QC 5 - 10		DAS 03 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
110	Handfinish - 1-1 Chemical-B4B	8 pcs	3/20/20		0.00	128.00	Handfinish - 1 - 1 - B4B		FEB 20 04-14
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 -		



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CANADA
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Container No: S262707**Part:** D2580-1**Job No:** 207804**Serial No/Batch:** S262707**Revision:** H**Inspector:****Exp Date:****Instructions:** Various STC's

Date: 03/11/20

				B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
120	QC 7	8 pcs	3/20/20	0.00	0.00
				QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	

125 Skidtubes - 2 - B4B	8 pcs	3/20/20	0.00	7.41	QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
					QC 7 - 83	
					QC 7 - 82	
					Skidtubes - 1 - B4B	
					Skidtubes - 2 - B4B	
130 QC 5	8 pcs	3/20/20	0.00	0.00	Skidtubes - 3 - B4B	<i>Mbr</i>
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	DAS
140 Packaging 3-1 - Stock - B4B	8 pcs	3/20/20	0.00	0.00	QC 5 - 3	03
					QC 5 - 43	9-89
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					Packaging 3 - 1 - B4B	<i>ll</i>
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	

					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
150	QC 21 - SA	8	3/20/20	0.00	0.00	QC 21 - SA - 21
		pcs				QC 21 - SA - 70
						QC 21 - SA - 53

DAS

21

9-05

APR 30 2020

Part Op 100 - (Skidtube) 1- Inspect mat'l D2500-1-190 for damage. 2-Drill pilot holes using drill jig DT 8149 A-BC-D 3-Open holes Descriptions: to 0.508" as per Dwg D2580 4-Debur holes per QSI002 section 4.2.3 and blow out all chips from inside of tube 5- Test fit inspection saddles on FWD & AFT saddle holes using DT9916.

101 - (QC5- Inspect part completeness to step on W/O)

110 - (Chemical Conversion Coat per QSI005 4.1)

120 - (QC7-Inspect Chemical Conversion Coat)

125 - (Skidtube) 1- Bond web in place per QSI 015. A/R Sikaflex-291 batch: 5268170 Sikaflex expire date: _____ Start time and date: _____ bond for 12hrs

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Identify as per dwg & Stock Location: _____) LOCATION : LG002

150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n - I' Beam Tube 4"	8 pcs (1 ea)	100-Skidtubes - 1	5206075
D2596	Web, 205 Skidtube	8 pcs (1 ea)	125-Skidtubes - 2 - B4B	5261168

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Skidtubes - 1	D2500-1-190	8	59	0
125-Skidtubes - 2 - B4B	D2596	8	10	0

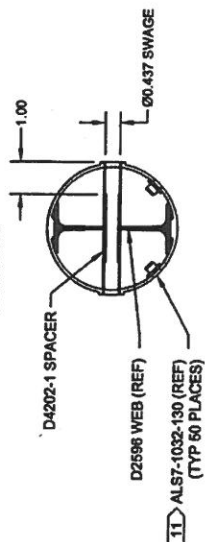
Part Specifications

Specifications could not be found.

Plex 3/4/20 12:46 PM Dart.lajeunesse.marie



SECTION B-B
SCALE 5X



**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.608 HOLES ONLY:**

1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

[illegible]

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		TITLE	205 SKIDTUBE ASSEMBLY

DECEMBER

2017 JUL 05

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Diagram of a circular component with labels: D2579 SPACER, WEB (REF), 30 (REF), and PLACES.

**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:**

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (4 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. DO NOT C'BORE

010.208

SEAL WITH SIKAFLEX-241/-201

DRILL PRIOR TO D2855 CAP INSTALLATION 2 PL

AN3-5A BOLT (1)

ANAS1149D0332J WASHER (1)

2 PL

D2855 AFT CAP

0.40

13

**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:**

1. INSERT D402-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

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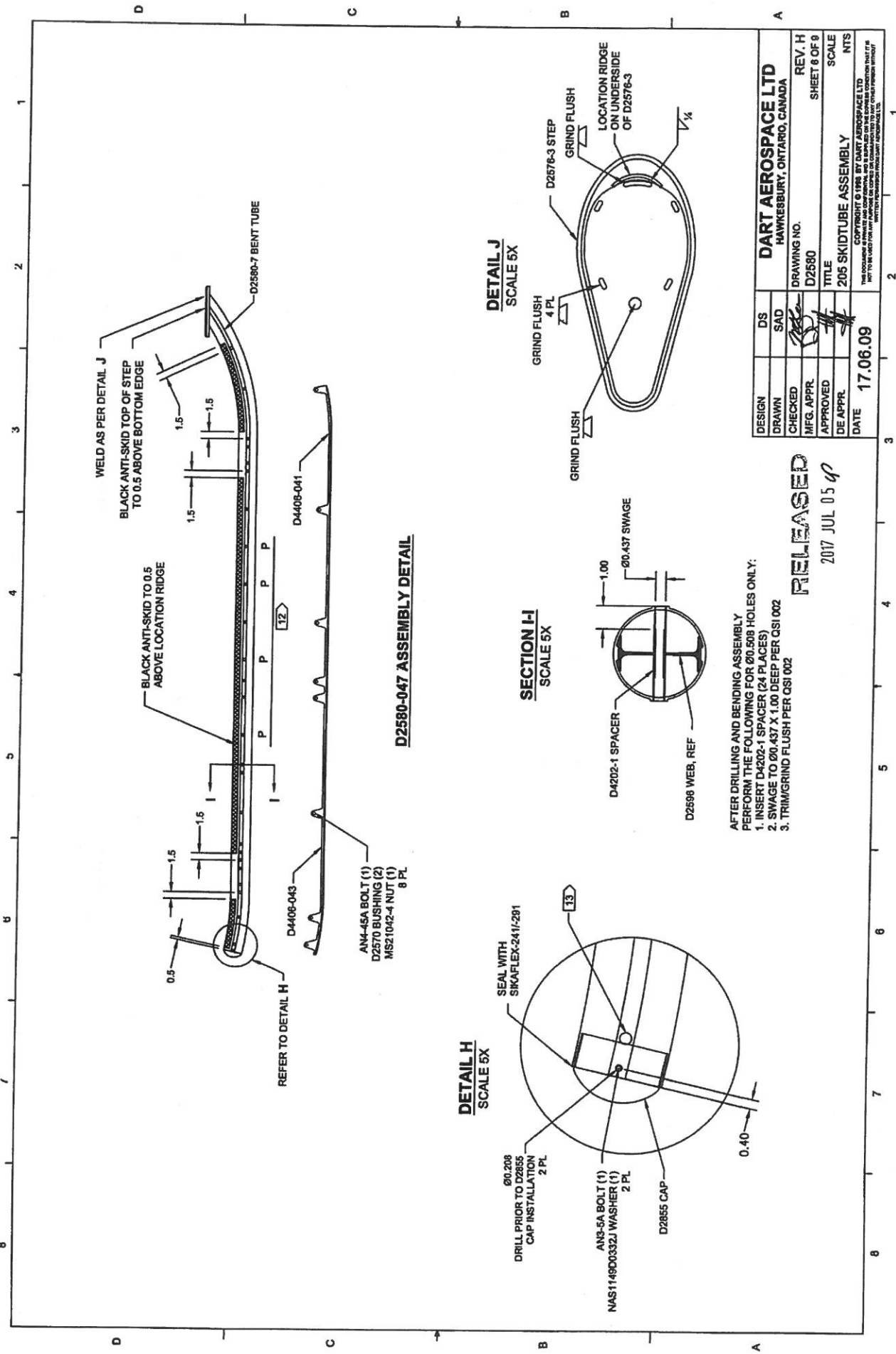
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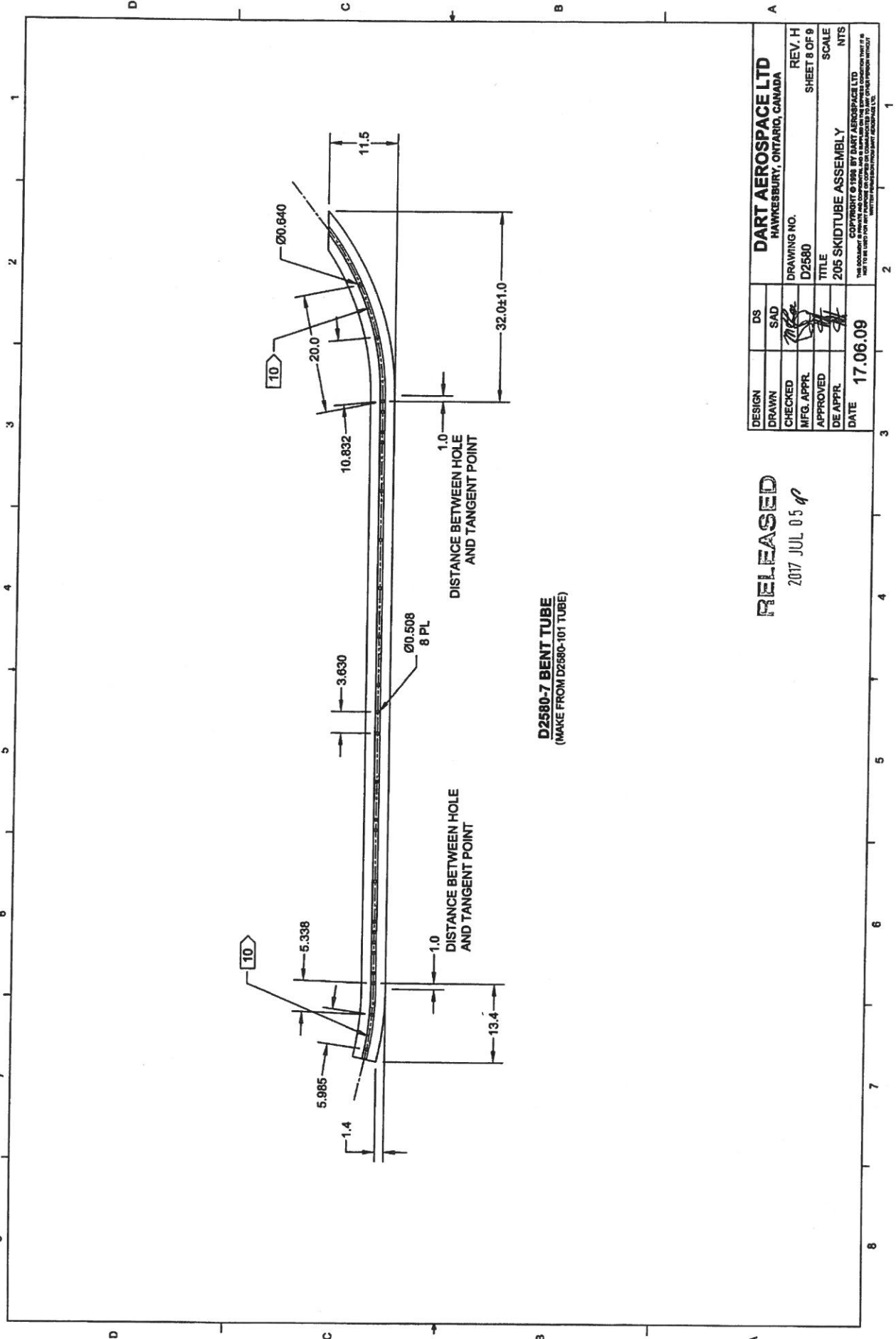
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AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

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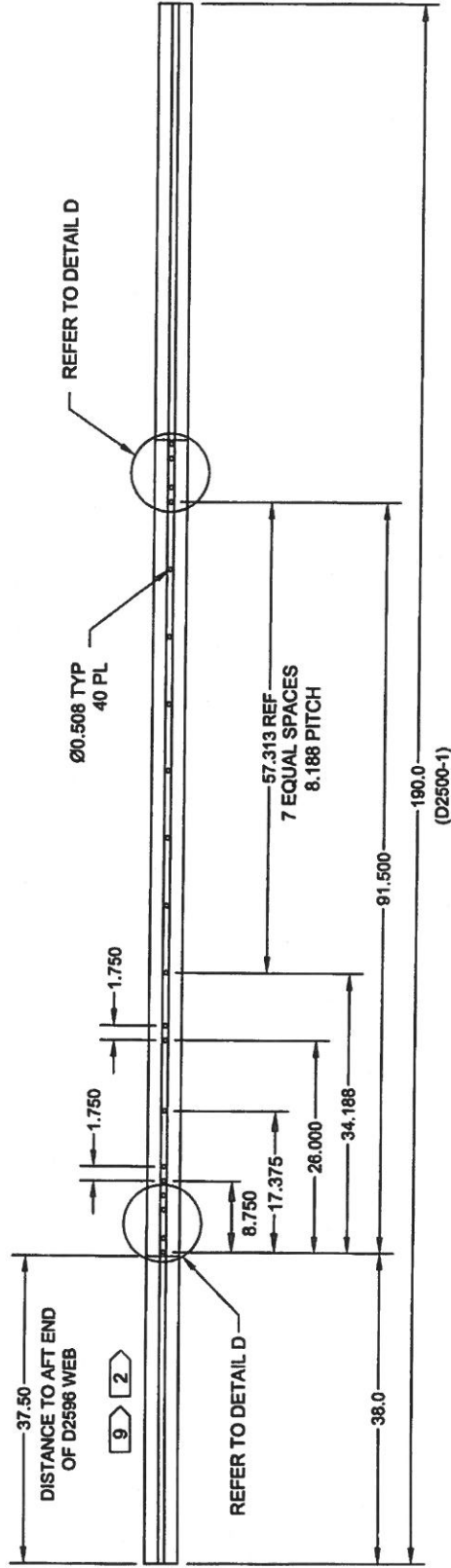




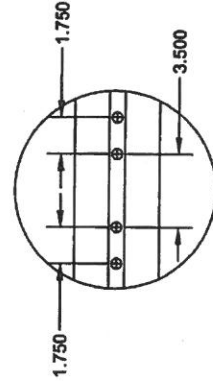
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D2580-101 TUBE



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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Eng. (Non-AW) ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Finishing ☐ Rec/Store/Packaging ☐ Skid-tube ☐ Machining ☐ Large Fab ☐				Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																				
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042) _____																						
Description Work Order Deviation				Disposition																								
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 33%;">Pressure/Forced</td> <td style="width: 33%;">Contamination</td> <td style="width: 33%;">Power Loss/Surge</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> </tr> </table> Other/Details: _____				Pressure/Forced	Contamination	Power Loss/Surge	Bending	Misaligned/off center	Folio/Program	Crushing	BOM/Route	Grain Direction	Cracks	Broken/Damage/Defect	Weld	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Marks/Chatter	Drill Holes	Out of Sequence	Mislabeled	Fit/Function	Off-set/Set-up
Pressure/Forced	Contamination	Power Loss/Surge																										
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Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled																										
Marks/Chatter	Drill Holes	Out of Sequence																										
Mislabeled	Fit/Function	Off-set/Set-up																										
Completed By				Lead hand / Supervisor																								
QC / QA Coordinator				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐																								